

Work Order ID 139863

December 10, 2015 1:16:09 PM

139863

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Item ID: D2199-31 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Details
 Start Date: 12/10/2015 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 12/23/2015 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: SH 20151210 Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2199	F

110	NC BRAKE	0.00							
110									
Brake NC	Memo	0.01							
Brake NC	Punch per Dwg D2199 and Spec Control Dwg D2638								
	Deburr								

FF 6 JAN 05 2016

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

(6) DAS 38 9-89 JAN 05 2016

130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>3:00</u> FINISH TIME: <u>4:00</u> OVEN TEMPERATURE: <u>160</u>								

6 16-01-11 34 38

Picklist Print

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Work Order ID: 139863

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Parent Item: D2199-31

D2199-31

Parent Item Name: Strut Details

Start Date: 12/10/2015

Required Date: 12/23/2015

Start Qty: 6.00

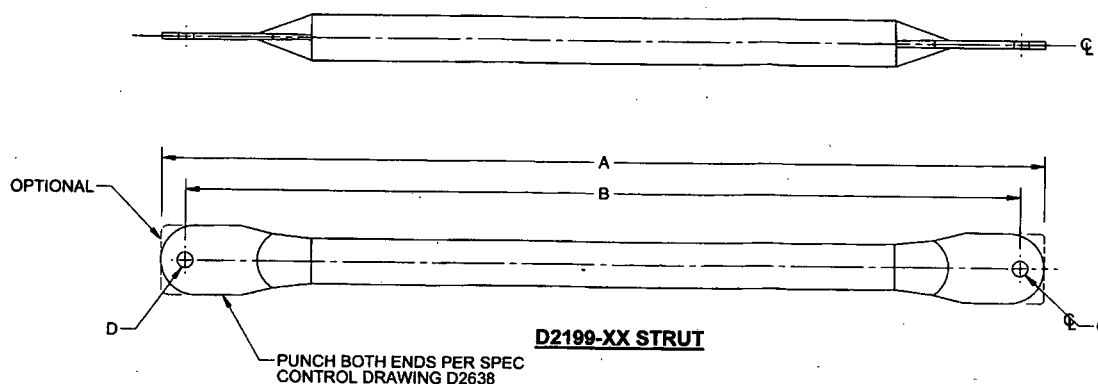
Required Qty: 6.00

Comments: IPP REV:A 15.02.05 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No				f	74.6010		8.210526			
M304TR0 750W 049										**		FF JAN 05 2016	
304 RD Tube .750 x .049W													

Location	Loc Qty	Loc Code
GA002	66.5473132	
M132270	0.00001	
M133131	0.0007242	
M133509	21.886579	
M133700	44.66	
MAT	8.0537347	
M133400	8.0537347	

8.210



PART NUMBER	A	B	C	D	WEIGHT (LBS)	FINISH
D2199-1	18.30	17.50	Ø 0.257	Ø 0.257	0.56	NOTE 2
D2199-3	5.80	5.00	Ø 0.257	Ø 0.257	0.17	NOTE 2
D2199-5	22.64	21.84	Ø 0.257	Ø 0.316	0.69	NOTE 2
D2199-7	14.74	13.94	Ø 0.257	Ø 0.257	0.45	NOTE 2
D2199-9	16.52	15.72	Ø 0.257	Ø 0.257	0.50	NOTE 2
D2199-11	23.60	22.80	Ø 0.257	Ø 0.316	0.72	NOTE 2
D2199-13	15.96	15.16	Ø 0.257	Ø 0.257	0.49	NOTE 2
D2199-15	17.57	16.77	Ø 0.257	Ø 0.257	0.54	NOTE 2
D2199-17	28.05	27.25	Ø 0.257	Ø 0.316	0.86	NOTE 2
D2199-19	18.90	18.10	Ø 0.257	Ø 0.257	0.58	NOTE 2
D2199-21	10.80	10.00	Ø 0.257	Ø 0.257	0.33	NOTE 2
D2199-23	26.18	25.38	Ø 0.257	Ø 0.316	0.81	NOTE 2
D2199-25	19.93	19.13	Ø 0.257	Ø 0.257	0.61	NOTE 2
D2199-27	27.34	26.54	Ø 0.257	Ø 0.316	0.84	NOTE 2
D2199-29	21.11	20.31	Ø 0.257	Ø 0.257	0.65	NOTE 2
D2199-31	15.55	14.75	Ø 0.257	Ø 0.257	0.45	NOTE 3

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING Ø 0.750 X 0.049 WALL
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF DART SPEC. M304TR0.750W0.049

2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3

3) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3

4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

7) IDENTIFICATION: IDENTIFY WITH DART P/N "D2199-XX" AND B/N BXXXXXX
PER QSI 044, 6.5.

8) WEIGHT: PER CHART

9) MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER.

RELEASED

2015 FEB 04

ECN 15-522 915-522

20151210 139863

REV.	DESCRIPTION	BY	DATE
F	INCORPORATED E1, REFORMATTED AND REDRAWN. ADDED -31. ADDED GREY SANDEX FINISH.	AJS	14.09.26
E	ADDED -23 AND -25 PER TSR A565M. ADDED TEMPLATE & SPEC CTRL. DWG REDRAWN IN CAD	KE	98.04.28
D	ADDED -21	N/A	N/A
C	ADDED -17 AND -19	N/A	N/A
B	ADDED -11, -13 AND -15	N/A	N/A
A	NEW ISSUE	JB	1993

APPROVED

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D2199	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT DETAILS	NTS
DATE	14.09.26	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

INSPECTION SHEET

LDAS

Engineering Approval:
(If necessary)

H:\FORMS\Quality Assurance\approved QA\Inspection Sheet revB